

303 Hex 0.500"

Work Order ID 80405

80405

Page 1

February-21-12 9:05:42 AM

Item ID: D3622-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ball Stud

Start Date: 21/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M L JDate: 12/02/12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3622

Rev C

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622 ,

FOLIO REV: AADWG REV: C

2-DEBURR AS REQUIRED

S.A. 12/03/06

20 0

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S.A. 12/03/06

20 0

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A. 12/03/06

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80405

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Item ID: D3622-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ball Stud
 Start Date: 21/02/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>SA</u>	0.00							
130									
Packaging	Memo	0.00				12/3/7			(20)
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 12/03/09
 MLJ
 12-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

February-21-12 9:05:46 AM

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Work Order ID: 80405

80405

Parent Item: D3622-1

D3622-1

Parent Item Name: Ball Stud

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	3.8915	0.108	2.273684			

M303H0 500

303 HEX BAR .500

Location

Loc Qty

Loc Code

MAT037

3.8915

109778

3.8915

2-3 36 m/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80405
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	.562	✓		Direct Caliper	80405
0.50	+/-0.030	.499	✓			
Ø0.394	+/-0.010	.395	✓			
Ø0.310	+/-0.010	.313	✓			
Ø0.215	+/-0.010	.218	✓			
0.155	+/-0.010	.157	✓			
0.313	+/-0.010	.315	✓			
0.478	+/-0.010	.478	✓			
0.630	+/-0.010	.635	✓			
0.125	+/-0.010	.125	✓			
0.563	+/-0.010	.565	✓			
1.19	+/-0.030	1.191	✓			
0.3125-24UNF-3A	+0.000/-0.072	.309	✓			
M.O.W.	Min = 0.3336 Max = 0.3363	.335	✓			

Measured by:	EC
Date:	12/03/06

Audited by:	BA
Date:	12/03/06

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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